

WHAT IS CLAIMED IS:

- 1 1. A method of applying a flowable substance to a
2 a web of wrapping material for rod-shaped products, com-
3 prising the steps of:
4 confining the web to movement along a predetermined
5 path;
6 directing at least one stream of flowable substance in $\langle \rangle$ manner
7 toward one side of the web and
8 ~~moving the stream relative to the path to provide~~
9 ~~the web with~~ \langle an at least partially non-linear \rangle ~~layer of~~
10 ~~flowable substance.~~

1 7. The method of claim 6, wherein said angle at
2 least approximates 30°.

1 8. The method of claim 6, wherein said flow is
2 substantially tangential to said cone.

1 9. The method of claim 3, wherein said flow
2 directing step includes causing the fluid substance to
3 flow along a preselected path prior to and during
4 issuance of the stream from the orifice of the nozzle.

1 10. The method of claim 3, further comprising the
2 steps of pumping the flowable substance from a source
3 to the orifice of the nozzle at a variable pressure and
4 providing an open-and-shut closure for the orifice.

1 11. The method of claim 10, wherein said pumping
2 step includes raising the pressure of the flowable sub-
3 stance to a predetermined value prior to opening of the
4 orifice.

1 16. The method of claim 14, wherein said step of
2 discharging the flowable substance includes discharging
3 the flowable substance from the orifice at a rate of at
4 least 2 grams per minute.

1 17. The method of claim 1, wherein the non-linear
2 layer is a spiral layer.

1 18. The method of claim 1, wherein the flowable
2 substance is an adhesive.

1 19. A method of making a filter for tobacco smoke,
2 comprising the steps of:

3 advancing a tow of filter material for tobacco
4 smoke along a first path;

5 advancing a web of wrapping material lengthwise
6 along a second path toward and into said first path;

7 applying to one side of the web in said second path
8 a non-linear layer of adhesive extending lengthwise of
9 the web; and

10 draping the adhesive-bearing web around the tow
11 in said first path.

1 20. The method of claim 19, wherein said applying
2 step includes applying adhesive to one of two marginal
3 portions and to an intermediate portion of the web adjacent
4 the one marginal portion, said draping step including
5 bonding the marginal portions to each other and bonding
6 the intermediate portion to the tow.

